

**Work Order ID 58720**

Tuesday, May 18, 2010 8:02:07 AM



Page 1

Item ID: D3259-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Access Panel Assembly

Start Date: 5/17/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 5/21/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 10-5-18

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D3259

Rev A1

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

10/06/02 (4)

110

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

Assemble D3259-041 as per Dwg D3259. □Note: Keep .040" Gap all around door.

5/20/06/02 (4)

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

5/10/06/02

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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# Picklist Print

Tuesday, May 18, 2010 8:02:12 AM

Page 1  
3

Work Order ID: 58720

Parent Item: D3259-041

Parent Item Name: Access Panel Assembly






Comments: IPP Rev:A New Issue 07-07-19 JLM Verified By:EC

Start Date: 5/17/2010

Required Date: 5/21/2010

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
D3161-5  Hinge 9.9"		Manufactured	No			110	Each	25.0000	14		5/10/06/02	
<div> <div>Location</div> <div>ST040</div> <div>43606</div> <div>47187</div> <div>47773</div> </div> <div> <div>Loc Qty</div> <div>25</div> <div>3</div> <div>10</div> <div>12</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> <div></div> </div>												
D3259-1  Panel		Manufactured	No			110	Each	5.0000	14		5/10/06/02	
<div> <div>Location</div> <div>ST180</div> <div>47850</div> </div> <div> <div>Loc Qty</div> <div>5</div> <div>5</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>												
D3259-3  Doubler		Manufactured	No			110	Each	5.0000	14		5/10/06/02	
<div> <div>Location</div> <div>ST180</div> <div>47189</div> </div> <div> <div>Loc Qty</div> <div>5</div> <div>5</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>												
D3259-5  Spacer		Manufactured	No			110	Each	0.0000	14		5/10/06/02	
D3259-7  Door		Manufactured	No			110	Each	4.0000	14		5/10/06/02	
<div> <div>Location</div> <div>ST180</div> <div>47851</div> </div> <div> <div>Loc Qty</div> <div>4</div> <div>4</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>												

14  
B10/06/02  
B43760 (20)  
(20)

14  
5/10/06/02  
4

14  
5/10/06/02  
4

14  
5/10/06/02  
4

B58750 (40)

W/O:		WORK ORDER CHANGES					
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# Picklist Print

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Page 2

Work Order ID: 58720

Parent Item: D3259-041

Parent Item Name: Access Panel Assembly







Comments: IPP Rev:A New Issue 07-07-19 JLM Verified By:EC

Start Date: 5/17/2010

Required Date: 5/21/2010

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
D3260-1  Spring		Manufactured	No			110	Each	22.0000	28		5/10/06/02	
					<u>Location</u> ST047			<u>Loc Qty</u> 22		<u>Loc Code</u>		
				47852				22				
* D3972-5  Grommet, Half, DZUS		Manufactured	No			110	Each	0.0000	28		5/10/06/02	
D3973-5  Receptable, Rigid, DZUS		Manufactured	No			110	Each	0.0000	28		5/10/06/02	
D3974-20  Stud, Wing Head, 5/16 DZUS		Manufactured	No			110	Each	0.0000	28		5/10/06/02	
MS20426AD4-4  Rivet		Purchased	No			110	Each	1,410.000	A16		5/10/06/02	
					<u>Location</u> ST316			<u>Loc Qty</u> 1410		<u>Loc Code</u>		
				15541				1410			16	
MS20470AD3-4  Rivet, Universal Head		Purchased	No			110	Each	11,441.00	28 144		5/10/06/02	
					<u>Location</u> ST319			<u>Loc Qty</u> 11441		<u>Loc Code</u>		
				111477				8332				
				15541				3109			144	

Tuesday, May 18, 2010 8:02:13 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Start Qty: 4.00

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MS20470AD3-5		Purchased	No			110	Each	4,362.000	40			
												
Rivet												



*Handwritten signature*  
5/10/06/02

Location

Loc Qty

Loc Code

ST319

4362

104817

3030

9682

1332

40

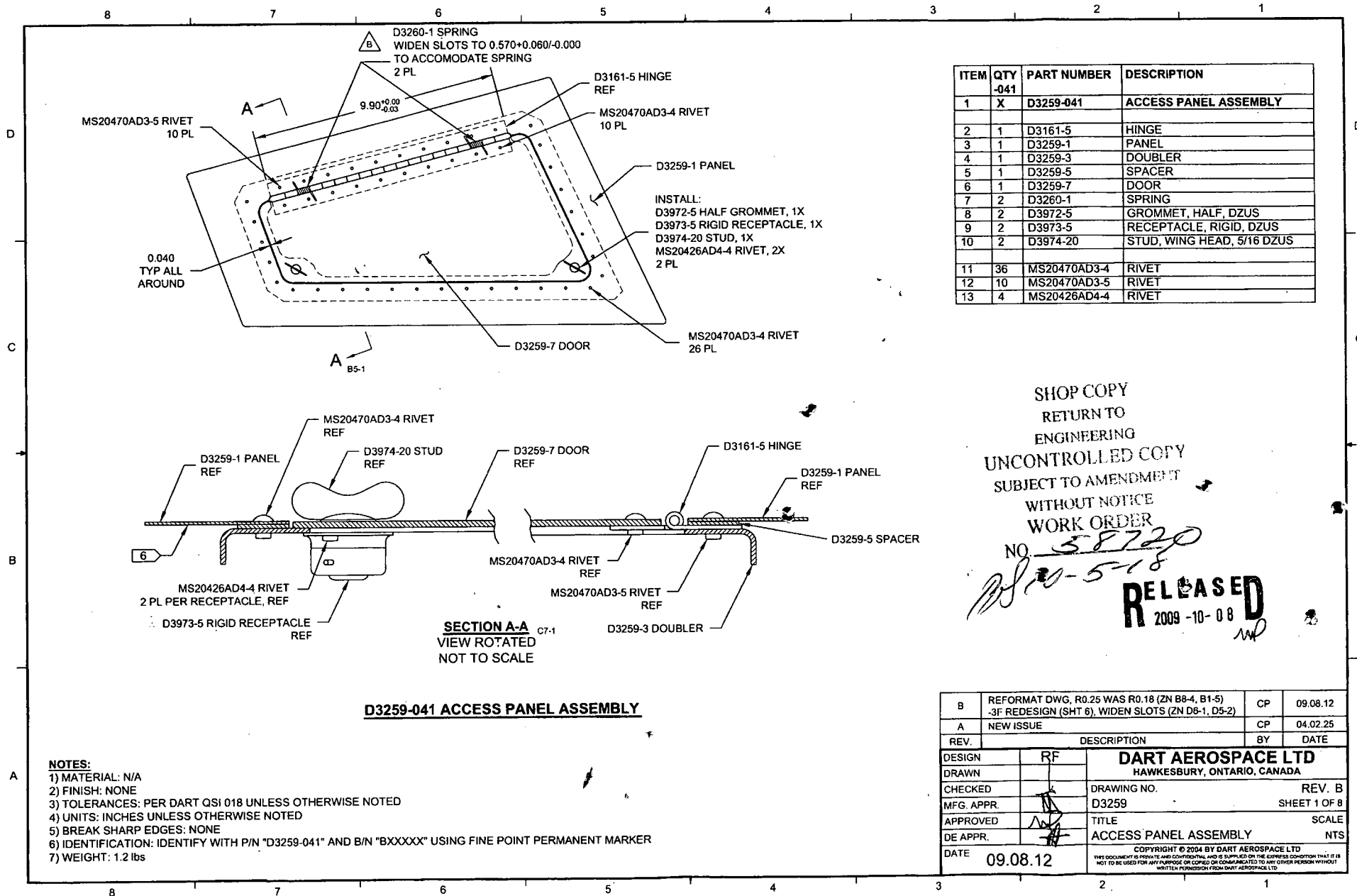
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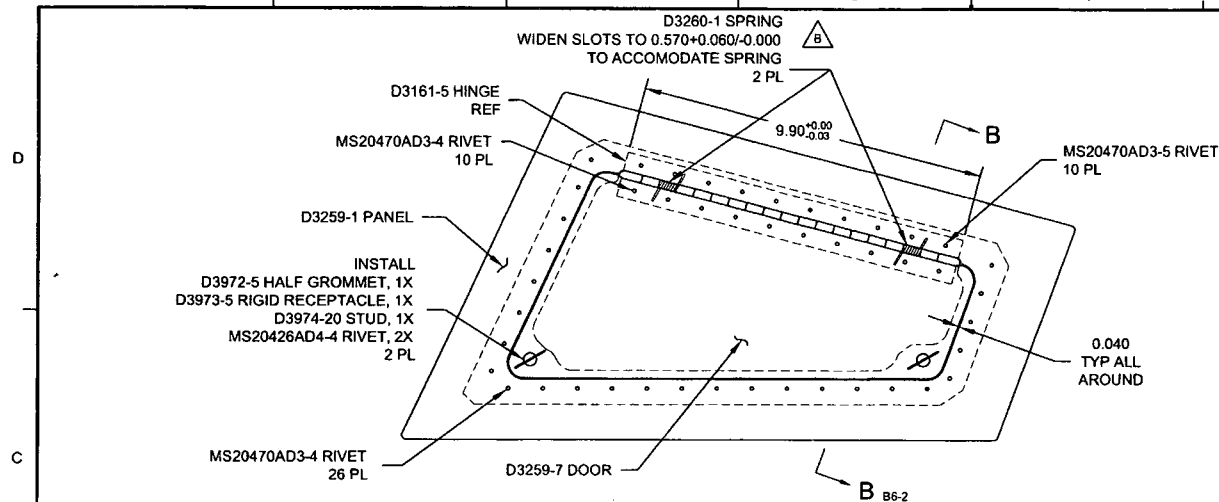
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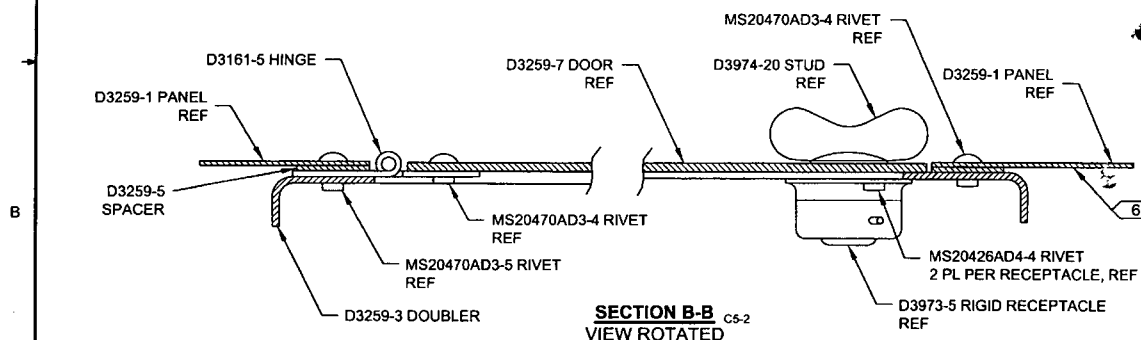
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



ITEM	QTY	PART NUMBER	DESCRIPTION
1	X	D3259-042	ACCESS PANEL ASSEMBLY
2	1	D3161-5	HINGE
3	1	D3259-1	PANEL
4	1	D3259-4	DOUBLER
5	1	D3259-5	SPACER
6	1	D3259-7	DOOR
7	2	D3260-1	SPRING
8	2	D3972-5	GROMMET, HALF
9	2	D3973-5	RECEPTACLE, RIGID, DZUS
10	2	D3974-20	STUD, WING HEAD, 5/16 DZUS
11	36	MS20470AD3-4	RIVET
12	10	MS20470AD3-5	RIVET
13	4	MS20426AD4-4	RIVET



### D3259-042 ACCESS PANEL ASSEMBLY

#### NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH P/N "D3259-042" AND B/N "BXXXXX" USING FINE POINT PERMANENT MARKER
- 7) WEIGHT: 1.2 lbs

61058720

RELEASED  
2009-10-08

DESIGN	RF	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3259	SHEET 2 OF 8
APPROVED		TITLE	SCALE
DE APPR.		ACCESS PANEL ASSEMBLY	NTS
DATE	09.08.12	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

8 7 6 5 4 3 2 1

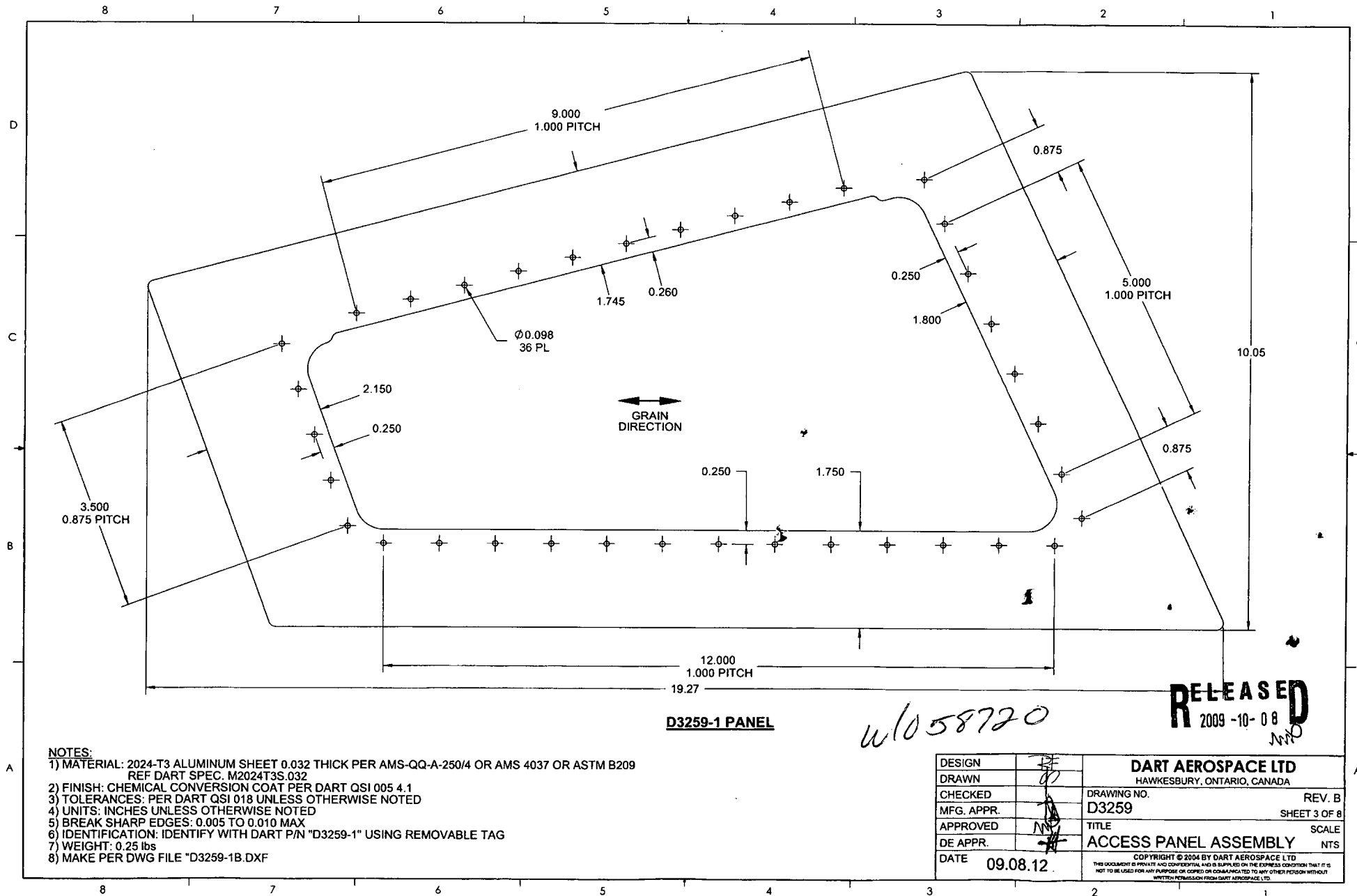
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**NOTE:** Date & initial all entries



# Dart Aerospace Ltd

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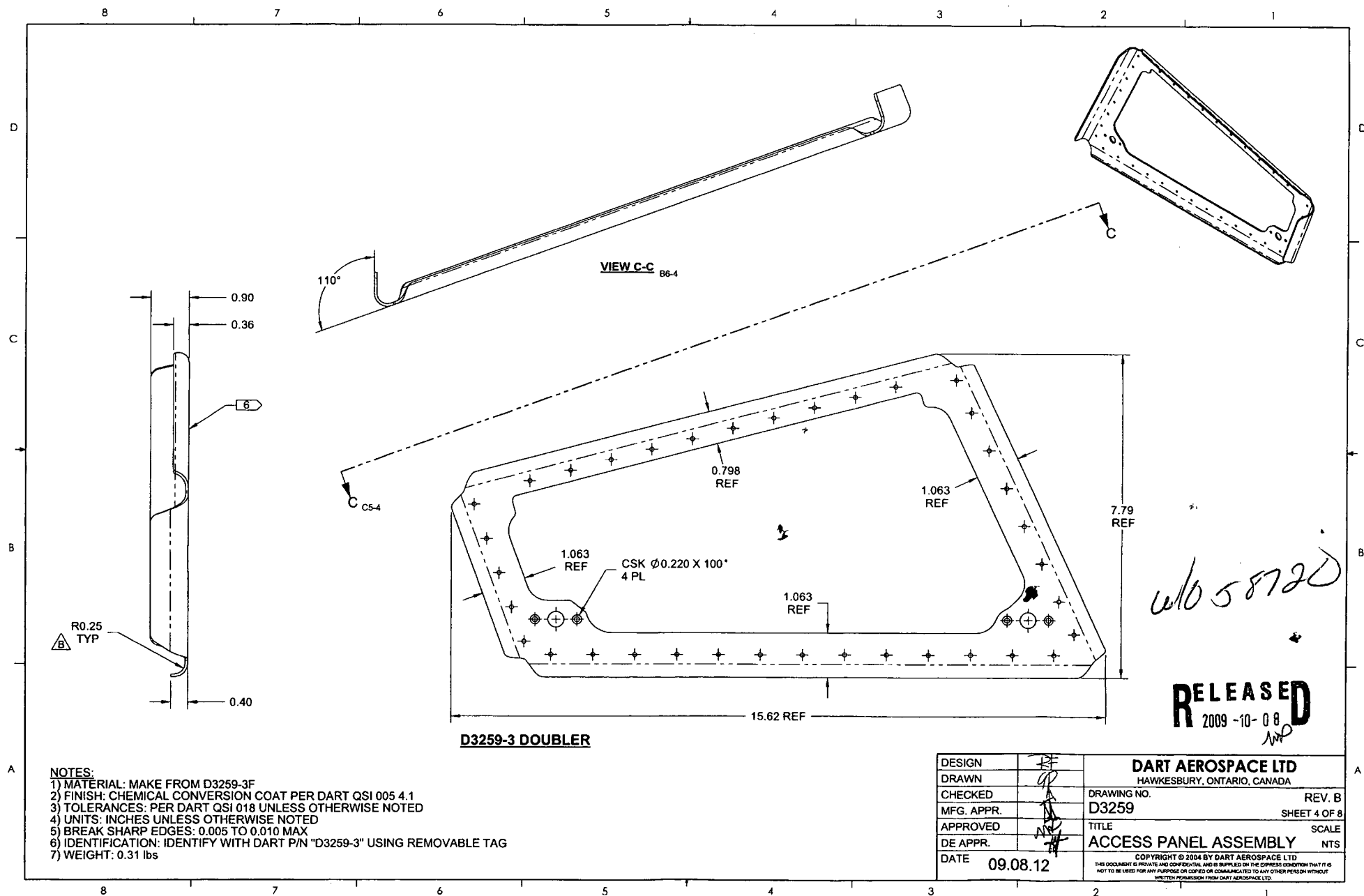
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**NOTE:** Date & initial all entries





RELEASED  
2009-10-08

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.	REV. B
D3259	SHEET 4 OF 8
TITLE	SCALE
ACCESS PANEL ASSEMBLY	NTS

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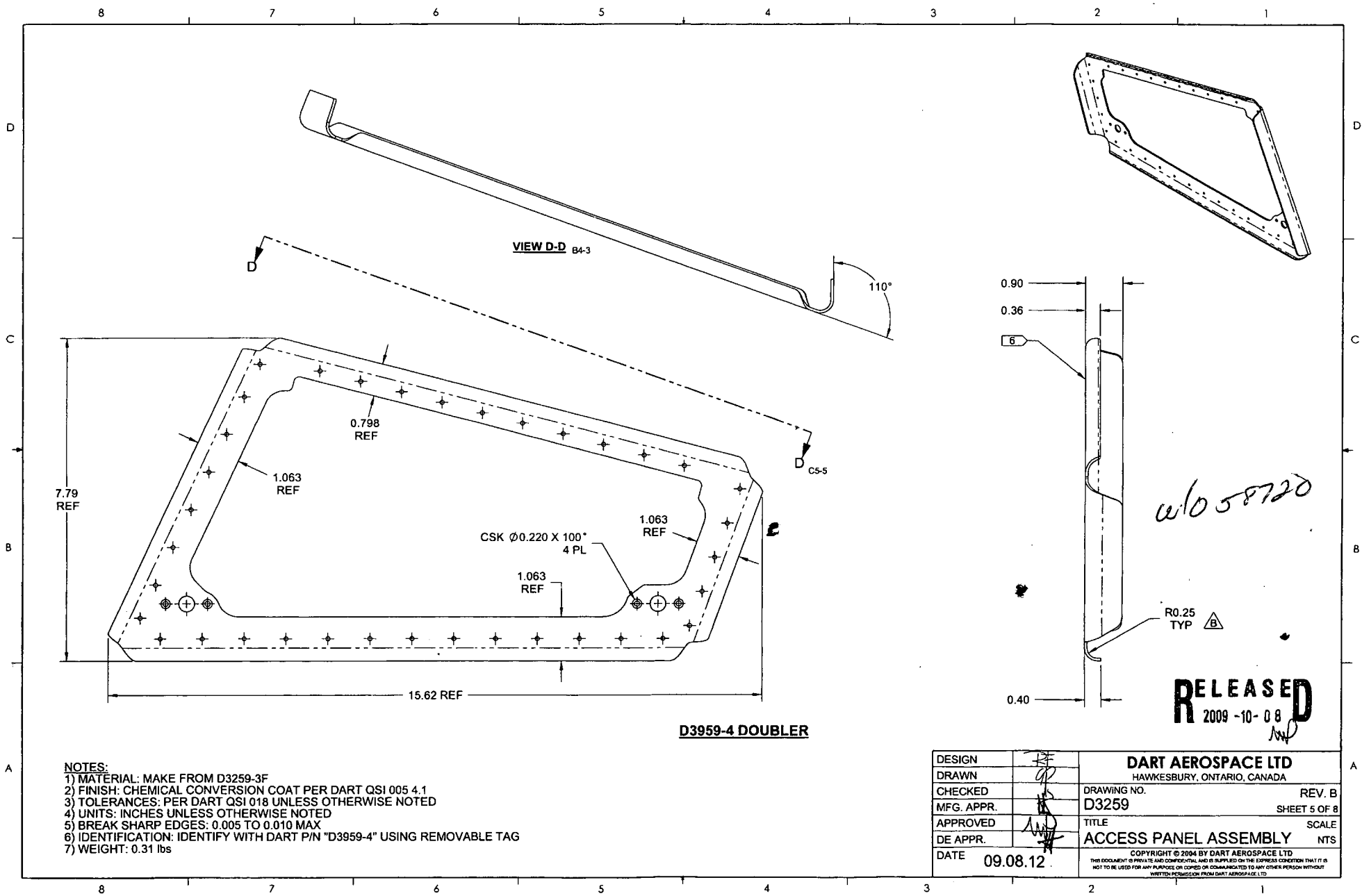
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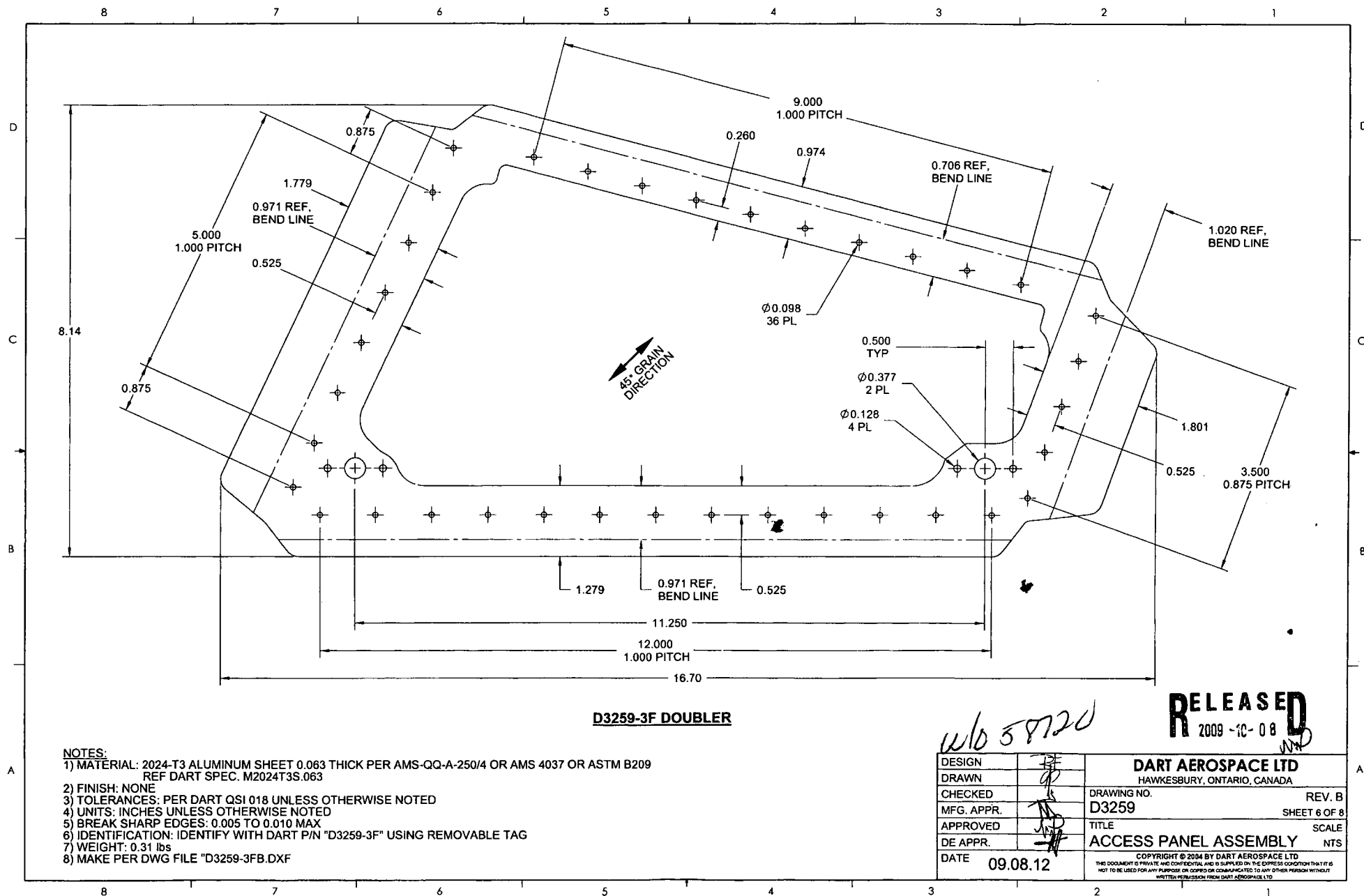
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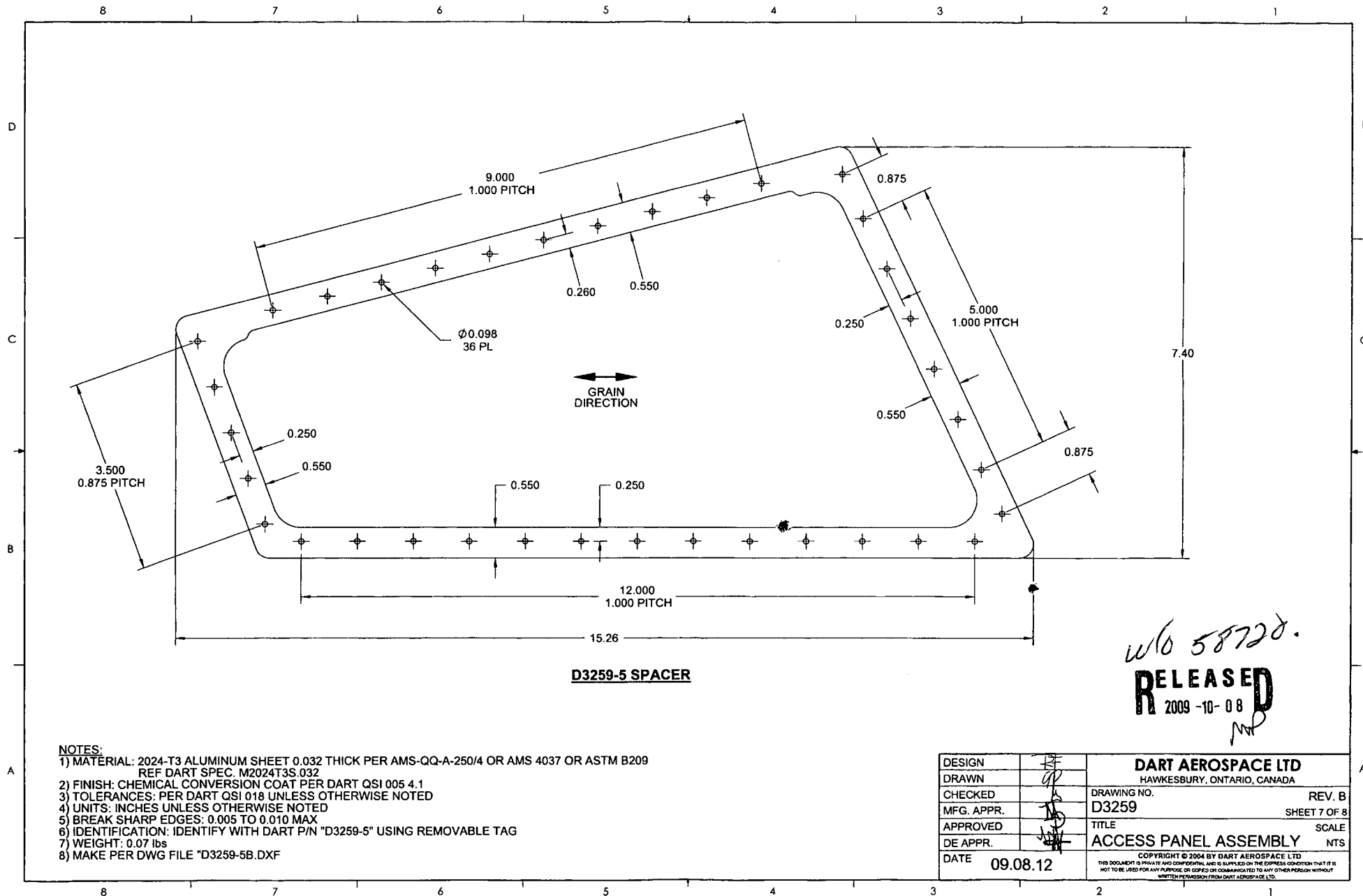
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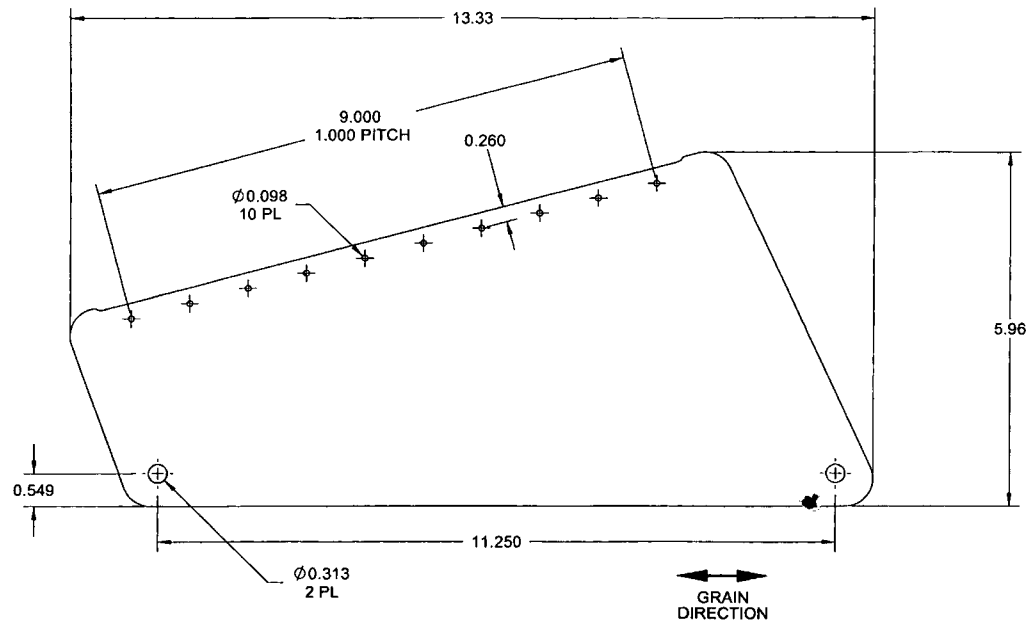
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**D3259-7 DOOR**

*W/O 58720*

**RELEASED**  
2009-10-08

**NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.063 THICK PER AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209  
REF DART SPEC. M2024T3S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3259-7" USING REMOVABLE TAG
- 7) WEIGHT: 0.35 lbs
- 8) MAKE PER DWG FILE "D3259-7B.DXF"

DESIGN	<i>RF</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>gp</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>JP</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>JP</i>	D3259	SHEET 8 OF 8
APPROVED	<i>JP</i>	TITLE	SCALE
DE APPR.	<i>JP</i>	ACCESS PANEL ASSEMBLY	NTS
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